



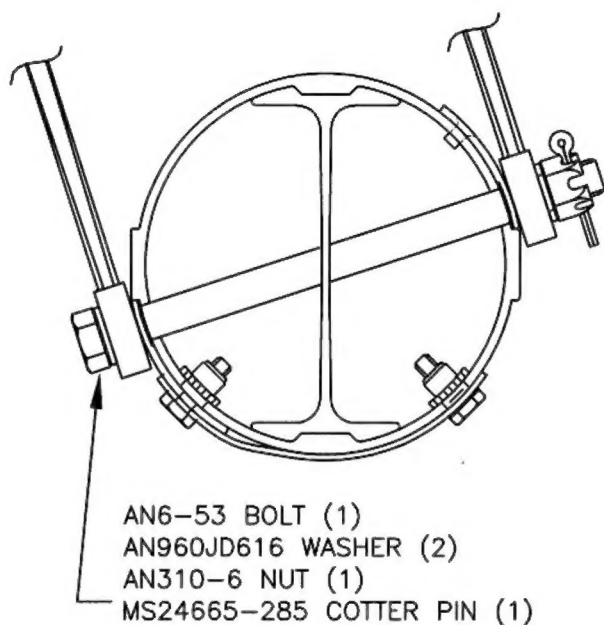
DESIGN	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. DSI 9262	REV. A SHEET 1 OF 1
DATE 03.05.14		TITLE SKIDTUBE REPAIR	SCALE NTS
A	03.05.14	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND D412-673 Rev. A
AND D205-634 Rev. A OR Rev. B
REF. CANADIAN STC: SH96-88
REF. FAA STC: SR000563NY

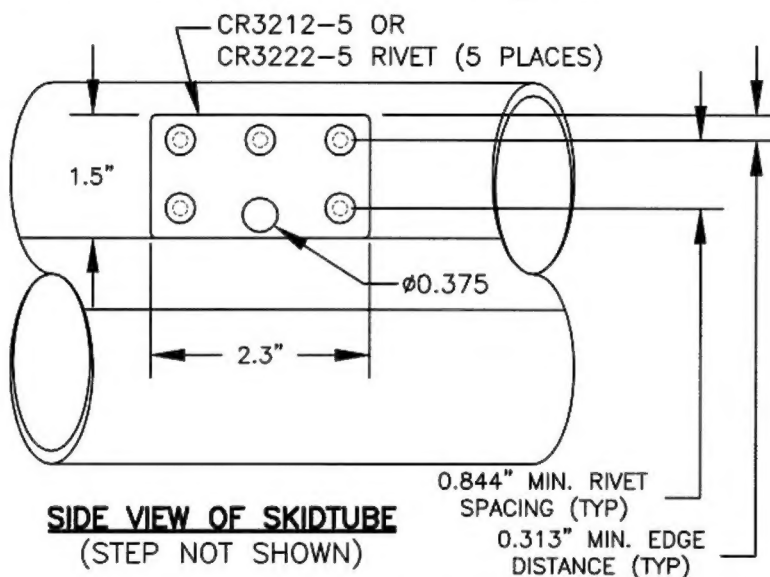
To repair elongated holes used to attach Bell electric step to Dart D205-634-011 skidtube:

- 1) Temporarily remove (4) bolts that attach electric step to Dart D205-634-011 skidtube.
- 2) Remove (4) ALS7-428-165 inserts.
- 3) Fabricate doublers from 1/4 hard 14 gauge (0.080") AISI 301/302/304/316 stainless steel per MIL-S-5059 as shown below.
- 4) Install over damaged area using CR3212-5 / CR3222-5 rivets and Proseal 890. The location of the doubler (and $\varnothing 0.375$ hole) may have to be adjusted fwd/aft to allow for fitting under the skidtube wearplates.
- 5) Reinstall electric step using hardware shown below. Transfer drill $\varnothing 0.375$ through web.



AN6-53 BOLT (1)
AN960JD616 WASHER (2)
AN310-6 NUT (1)
MS24665-285 COTTER PIN (1)

FWD/AFT VIEW OF SKIDTUBE



SIDE VIEW OF SKIDTUBE
(STEP NOT SHOWN)

0.844" MIN. RIVET
SPACING (TYP)
0.313" MIN. EDGE
DISTANCE (TYP)

REFERENCE ONLY.
NEVER APPROVED.

CUSTOMER USED AN5 BOLTS IN
COMBINATION WITH D2570 BUSHINGS

#03.06.24

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: _____
D. SHEPHERD (DE # 02)

DATE: 03.05.14
CERT. NO.: SH96-88
ISSUE NO.: 1-2

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